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D130-1046-113
Job Sheet 197618



Part No: D130-1046-113

Job Qty: 1 pcs

Part Name: EC130T2/H130 Cable Cutter Upper Fixed Provisions



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/11/19

Job Tracking No:

Due Date: 7/22/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D130-1046 REV.B IPP REV:A 18.02.20 NEW ISSUE DD VERF:JFS IPP REV:B 18.03.13 AS PER IIN
REV.PA7 DD VERF:JFS IPP REV:C 18.08.23 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		7/22/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

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Container No: S197640

Part: D130-1046-113

Job No: 197618

Serial No/Batch: S197640

Revision: B

Inspector:

Exp Date:

Instructions: FAA STC SR02609SE 18/08/09, TGA LoA C-18-0702 18/09/14

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					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120 QC 4	1 pcs	7/22/19	0.00 0.00	QC 4 - 28		
				QC 4 - 58		
				QC 4 - 69		
				QC 4 - 9		
				QC 4 - 46		
				QC 4 - 68		
				QC 4 - 72		
				QC 4 - 74		
				QC 4 - 75		
130 Packaging 3-1 - Stock - B4B	1 pcs	7/22/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
135 DC - 1 - B4B	1 pcs	7/22/19	0.00 0.00	DC - 1 - B4B		
				DC - 2 - B4B		
140 QC 21 - FG	1 pcs	7/22/19	0.00 0.00	QC 21 - FG - 21		
				QC 21 - FG - 70		
				QC 21 - SA - 53		

Part Op 110 - Packaging1 (Pick Kit)
 Descriptions: 120 - QC4 (QC4- 100% Inspect kits for completeness)
 130 - Packaging3-1 Identify and pack for shipping as per PPP D130-1046-113 Location: _____

135 - (Document Control) Photocopy bluefile & type labels per PPP D130-1046-113 CHG001
 140 - QC21 (QC21- Final Inspection - Work Order Release)

010879

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CR7621S-04-02	Rivet, Blind	11 Ea (11 ea)	110-Packaging 1 - Pick Kit	5194384
CR7621S-04-04	Rivet, Blind	9 Ea (9 ea)	110-Packaging 1 - Pick Kit	5124564
D5563-1	Placard	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5067090
D5600-1	Doubler Angle	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5123852
D5603-M6-9.5	Insert	6 pcs (6 ea)	110-Packaging 1 - Pick Kit	5061959
D5604-1	Drill Bushing	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5135065

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	CR7621S-04-02	11	50	0
	CR7621S-04-04	9	32	0
	D5563-1	1	47	0
	D5600-1	1	7	0
	D5603-M6-9.5	6	24	0
	D5604-1	1	7	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

ITEM	QTY -113	P/N	DESCRIPTION	MANUFACTURER	ALTERNATE PART
	X	D130-1046-113	FIXED PROVISIONS, UPPER, EC130 T2		
1	1	D5600-1	DOUBLER, ANGLE		
2	1	D5563-1	PLACARD		
3	6	D5603-M6-9.5	INSERT		
4	1	D5604-1	DRILL BUSHING		
5	11	MS21141U0402W	MAXIBOLT, BLIND, PAN HEAD		MS21141S0402, CR7621S-04-02
6	9	MS21141U0404W	MAXIBOLT, BLIND, PAN HEAD		MS21141S0404, CR7621S-04-04
7	A/R	PR1422	SEALANT	PPG (DESOTO)	P/S 890 OR MIL-S-8802 COMPLIANT
8	A/R	BJOA0930	BROWN MICROBALLOONS, PHENOLIC (FILLER)	VARIOUS	BJO-0930
9	A/R	EA9396 (PART A&B)	ADHESIVE (BLUE BASE & RED HARDENER)	HENKEL	

2
2
2

NOTES:

- 1) ALL DIMENSIONS IN MILLIMETERS
- 2) NOT INCLUDED IN KIT. TO BE PROVIDED BY INSTALLER.
- 3) LOCATE POSITION FROM D5556-041 CUTTER ASSEMBLY, UPPER.
- 4) INSTALL INSERTS ACCORDING TO THE FOLLOWING INSTRUCTIONS:
 - a) DRILL Ø6.1 THRU PANEL.
 - b) OPEN UP HOLE IN INTERIOR OF AIRCRAFT SKIN TO INSERT DIAMETER, Ø17.4. DO NOT PENETRATE TOP SKIN.
 - c) REMOVE HONEYCOMB CORE BACK TO DIAMETER SHOWN, Ø25 MIN.
 - d) INSTALL INSERT THROUGH BOTTOM HOLE. SECURE USING A SCREW COATED WITH RELEASE AGENT.
 - e) FILL CORE CAVITIES USING ADHESIVE (ITEM 9) AND MICROBALLOONS (ITEM 8).
 - f) CURE THE ADHESIVE AT ROOM TEMPERATURE FOR 24 HOURS.
 - g) REMOVE SCREW SECURING INSERT.
- 5) PICK UP EXISTING RIVETS
- 6) IF D5600-1 DOUBLER (ITEM 1) INTERFERES WITH EXISTING LABEL, INSTALL LABEL APPROXIMATELY AS SHOWN. ENSURE LABEL CONTENT MATCHES LABEL COVERED BY D5600-1 DOUBLER.
- 7) IF THESE RIVETS DO NOT EXIST ON AIRCRAFT, INSTALL PER DIMENSION SHOWN
- 8) IF THESE HOLES ENCR OACH ON EXISTING RIVET HOLES LOCATIONS, ELONGATE HOLE IN CANOPY FRAME ONLY TO ENCOMPASS EXISTING RIVET HOLES. DO NOT ELONGATE HOLES IN D5600-1 DOUBLER (ITEM 1).
- 9) IF EXISTING RIVETS INTERFERE, POSITION THESE RIVETS EQUIDISTANT FROM NEIGHBORING RIVETS/HOLES.
- 10) PICK-UP EXISTING RIVET IF POSSIBLE OR LOCATE ON THE AIRCRAFT CENTERLINE.

B	D5563-1 WAS D5601-1 (TYPO)	CP	18.06.26
A	NEW ISSUE	AJS	18.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	JMH	DART AEROSPACE USA, INC.	
DRAWN	CP	EUGENE, OR	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	N/A	D130-1046-113	SHEET 1 OF 4
APPROVED	DSW	TITLE	FIXED PROVISIONS, UPPER, SCALE
DE APPR.	CP	EC130 T2	NTS
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APPROVED

Change Record

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Part Number: D130-1046-113

Description: Fixed Provisions, Upper, EC130 T2

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